Tuesday, August 24, 2010 3:08:35 PM



Page 1

Item ID:

D206-667-103BL

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Crosstube Fwd, Blue

**Start Date:** 

8/25/2010

Start Qty: 1.00

Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

Process Plan: UMK Approvals:

Date: 10-8-24 Tooling:

Date:

Run

**Required Date: 9/10/2010** 

QC:

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop

Start

Sequence ID/ **Work Center ID** Draw Nbr

Operation **Description** 

**Revision Nbr** 

Set Up/ **Run Hours**  **Tool ID** 

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

D206-667-143 C

100

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-103 CHG004

110

Packaging Packaging

Pick Kit

Packaging

0.00

0.00

120

CNC Bend 2

**BENDING MACHINE - CROSSTUBES** 

Memo

0.00

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-143 using CNC bender program

MB 10-09-14

W/O:	·		WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)	-		
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Page 2

Item ID:

D206-667-103BL

Accept



Setup Start



**Revision ID:** 

Item Name:

Crosstube Fwd, Blue

**Cust Item ID:** 

Stop

**Start Date:** 

8/25/2010

Required Date: 9/10/2010

Start Qty: 1.00 Req'd Qty: 1.00

**Customer:** 

Reference:

A	nı	r	กข	ลโ	s:

Process Plan:

Date: Tooling: Date:

Run Start



QC: \_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

**Description** 

Operation

QC15- Crosstube Dimensional Check

Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept Qty Qty

Reject Reject Number

Insp. Stamp

130

Memo

0.00

Quality Control

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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Page 3 .

Tuesday, August 24, 2010 3:08:35 PM

Item ID:

D206-667-103BL

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Crosstube Fwd, Blue

**Start Date:** 

8/25/2010

Start Otv: 1.00

**Required Date: 9/10/2010** Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference: "

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Process Plan:

Date: Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Date:

Date:

Start



Stop



Sequence ID/: Work Center ID

140

Crosstubes

Crosstubes

Operation **Description** 

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept **Qty** 

Reject **Qty** 

Run

Reject Number

Insp. Stamp

Crosstubes

Memo

0.00

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143 Inside of Cuff(Donot engrave on outside of tube)

10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

W/O:			W	ORK ORDER CHANG	ES			······································		
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Page 4

Item ID:

D206-667-103BL

Accept



Setup Start



**Revision ID:** 

Item Name:

Crosstube Fwd, Blue

Start Oty: 1.00

**Cust Item ID:** 

**Customer:** 

**Start Date:** 8/25/2010 **Required Date: 9/10/2010** 

Req'd Oty: 1.00

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Start

Stop

QC:\_\_\_\_\_

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

150

HandFXtube

Hand Finishing Crosstubes

Operation **Description** 

Crosstubes Chemical Conversion

Memo

Set Up/

Run Hours 0.00

Tool ID

Tool # Plan Code Accept Reject Qty Qty

Run

Reject Number

Insp. Stamp

160



Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

oslipola d

170

W/O:			WC	ORK ORDER CHANG	iES .			
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Page 5

Item ID:

D206-667-103BL

Accept

Setup Start

Stop

**Revision ID:** 

Item Name:

Crosstube Fwd, Blue

**Start Date:** 

8/25/2010

Start Qty: 1.00

**Required Date: 9/10/2010** Reg'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

**Approvals:** 

Process Plan: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Plan

Code

Tool #

Start

Stop

Reject

Run

Sequence ID/ **Work Center ID** 

180

Outsource2 Outsource process - NDT Operation Description

Outsource process - NDT per QSI038 4.1

**CROSSTUBES** 

QC: \_\_\_ Date:

Set Up/ **Run Hours** 

7/01.12615

Qty

Accept

Qty

Insp. Number Stamp

CL 10/9/22 0

Reject

Packaging Packaging

190

Packaging

Memo

Memo

0.00

0.00

0.00

Ensure copy of NDT results attached to work order.

CX 10/9/221)

200

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

m 10 09 20 (1)

W/O:									
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**Required Date: 9/10/2010** 

Tuesday, August 24, 2010 3:08:35 PM

Page 6

Item ID:

D206-667-103BL

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Crosstube Fwd, Blue

8/25/2010

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan: Date:

Tooling:

Date:

Tool ID

Date:

Start

Stop

Run



Sequence ID/

**Work Center ID** 210

SprayPaint

**Spray Painting** 

Primer: 110199

clear: 110896

Operation

SPC (Y/N):

Set Up/

**Run Hours** 

Tool # Plan Code

Accept **Qty** 

Reject **Qty** 

Reject Insp.

Number Stamp

SprayPaint

Description

Memo

0.00

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2

Date: \_\_\_\_\_

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 9:00 Fininsh Time: 10 200

PAINT:

Start Time: 260 Finish Time: 3100

220

QC14- Inspect Spray Paint

0.00

Quality Control

Memo

0.00

Wrap in plastic bag to protect from scratches

at 10-09-23

W/O:			WO	RK ORDER CHANG	SES		ì		
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NCR:		\	WORK ORDE	R NON-CONFORM	ANCE (NCR)	)			
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DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector	
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Page 7

Item ID: **Revision ID:**  D206-667-103BL

Accept



Setup Start



Item Name:

Crosstube Fwd, Blue

**Start Date:** 8/25/2010 **Required Date: 9/10/2010** 

Start Oty: 1.00 Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date: Tooling:

Date:

Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Start

Sequence ID/ **Work Center ID** 

230

Crosstubes

Crosstubes

**Operation Description**  Set Up/ **Run Hours** 

Tool # Plan Code Accept Qty

Reject Qty

Reject Insp. Number

10 OR 23 0

Stamp

Crosstubes

Memo

0.00

0.00

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft

holes should be facing up.
A/R Magnobond 6398: 114158

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron

paint. W 10.00 27

QC5- Inspect part completeness to step on W/O

240

QC

Sidor 127

Quality Control

Memo

W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Page 8

Item ID:

D206-667-103BL

Accept

Setup Start



**Revision ID:** 

Item Name:

Crosstube Fwd, Blue

Stop

**Start Date:** 

8/25/2010

Start Oty: 1.00 Req'd Oty: 1.00

Date: \_\_\_\_\_

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: Tooling:

Run Date:

Start



Required Date: 9/10/2010

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

250

Packaging

Operation Description

Pick Kit

**Run Hours** 0.00

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject

Reject Number Stamp

Insp.

Packaging

QC4-100% Inspect kits for completeness

0.00

260

QC

**Quality Control** 

Memo

Memo

Elolor /28

270

Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPP D206-667-103

Location: PPP Rev:

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Tuesday, August 24, 2010 3:08:35 PM



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Item ID:

D206-667-103BL

Accept



Setup Start



**Revision ID:** 

Item Name:

Crosstube Fwd, Blue

Stop

**Start Date:** 

8/25/2010

Start Qty: 1.00 Req'd Qty: 1.00

**Cust Item ID: Customer:** 

Tool ID

Reference:

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Process Plan:

Date:

Tooling:

Date: \_\_\_\_\_

Start



Required Date: 9/10/2010

QC:

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_

Stop



Sequence ID/

Work Center ID

280

QC Quality Control Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

Tool # Plan Accept Qty Code

Reject Qty

Run

Reject Number Stamp

Insp.

Memo

0.00

0.00

MF 10-9-28

W/O:			W	ORK ORDER CHANG	ES				
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#### **Picklist Print** Tuesday, August 24, 2010 3:08:34 PM Work Order ID: 61418 Parent Item: D206-667-103BL Parent Item Name: Crosstube Fwd, Blue **Start Date: 8/25/2010 Required Date: 9/10/2010** Start Qty: 1.00 Required Qty: 1.00 IIP RevA: new issue DD .09.11.23 verified by:EC Comments: Component Item ID/ Replacement Mfg/ Bin Primary Last Qty per Kit Total Route Unit of Qty on Qty Date Item Name Item ID Purch Item Location Location Seq ID Measure Hand Issued Qty Issued AN5-30A Purchased No 250 110.0000 Each 4 **BOLT** Location Loc Qty Loc Code ST339 110 102473 4 105144 10 112933 21 114437 25 114941 50 AN5-32A Purchased No 250 Each 204.0000 Bolt Location Loc Qty Loc Code ST340 204 113121 4 M114056 114056 50 114405 50 115016 50 115108 50

AN5-7A

Purchased

No

**Location** Loc Qty Loc Code ST337 200 100826 10 109061 4 113149 186

250

Each

200.0000

10

10

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Status

W/O: WORK ORDER CHAN					ES		,		
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Tuesday, August 24, 2010 3:08:34 PM

Work Order ID: 61418 Parent Item: D206-667-103BL Parent Item Name: Crosstube Fwd, Blue Start Date: 8/25/2010 **Required Date: 9/10/2010** Start Qty: 1.00 Required Qty: 1.00 NAS1149D0563J Purchased No 250 Each 34.0000 18 18 Washer Location Loc Qty Loc Code ST 103694 18 107534 12 109287 4 AN970-4 Purchased No 250 Each 78.0000 Washer Lecation Loc Oty Loc Code ST349 78 112991 28 115266 50 D206-667-103TRN Manufactured 110 Each 2.0000 Crosstube Turning DetailL Location Loc Qty Loc Code FG

60143 60144

LG

W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Picklist Print
Tuesday, August 24, 2010 3:08:34 PM

Work Order ID: 61418	1,000									
<b>Parent Item:</b> D206-667-103BL										
Parent Item Name: Crosstube Fwd, E	Blue						tart Date: 8 Start Qty: 1		· ·	Date: 9/10/2010 i Qty: 1.00
D2873-043	Manufactured	No		230	Each	52.0000	2	2	m .	0 09.27
			Location	Loc	<u>Oty</u>	Loc Code				
			LG		32					
			53966		10					
			56466		2					
			57337		20					
			ST		20					
D2972 045			60981		20					
D2873-045  Nut Plate Assembly	Manufactured	No		230	Each	48.0000	2	2	Υ\	10.09.2
			<b>Location</b>	Loc	e Qty	Loc Code				
			LG		48					
			53968		9					
			57336		19					
D2891-1			60982		20					
2.25 Support	Manufactured	No		230	Each	69.0000	2	2	m	10.09.23
			<b>Location</b>	Log	e Qty	Loc Code				
			LG		69					
			46159		15					
			50952		18					
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Tuesday, August 24, 2010 3:08:35 PM

Work Order ID: 61418 Parent Item: D206-667-103BL Parent Item Name: Crosstube Fwd, Blue **Required Date: 9/10/2010** Start Date: 8/25/2010 Required Oty: 1.00 Start Qty: 1.00 D3595-063-395 Manufactured 230 Each 46.0000 RUBBER CUSHION Loc Code Location Loc Qty FP 10 10 44667 ST 36 60585 36 cut (4)0.063" X 3.95" MS20601-AD4W8 No Purchased 230 Each 286,0000 14 14 RIVET Location Loc Qty Loc Code ST322 286 108521 98 112203 188 MS21042L5 250 Purchased No Each 657,0000 Nut Loc Qty Location Loc Code ST139 157 114813 157 ST300 500 115156 500

W/O:		WORK ORDER CHANGES							
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DATE	STEP	Description of NC Section A		Action Description	Sign 8				Approval QC Inspector
DATE	STEP	· Section A		Action Description Chief Eng	Sign 8				Approval QC Inspector
DATE	STEP	· Section A		Action Description Chief Eng	Sign 8				Approval QC Inspector

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#### **Picklist Print**

\*Tuesday, August 24, 2010 3:08:35 PM

Page 5

Work Order ID: 61418

Parent Item:

D206-667-103BL

Parent Item Name: Crosstube Fwd, Blue



**Start Date: 8/25/2010** 

Required Date: 9/10/2010

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Clamp (per MIL-DTL-8783C)

Purchased

No

230

Each 89.0000

Location	Loc Qty	Loc Code	
LG	89		
112624	18		
114687	21		
114779	24		
115057	26		

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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	R	esolution:	Dispositi	on:	_ QA: N/C Clo	osed:	Date: _				
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		Description of NC Corrective Action Section B				Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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Item Qty Part Number Description -143 D206-667-143 Х CROSSTUBE ASSEMBLY (206L HIGH FWD) D6002-115 CROSSTUBE 3 D2873-043 NUT PLATE 4 D2873-045 NUT PLATE 5 2 D2891-1 SUPPORT 6 4 D3595-063-395 RUBBER CUSHION 4 MS21920-20 CLAMP (OR MS21920-21) 8 14 MS20601AD4W8 RIVET (OR NAS9302B-4-8) A/R MAGNOBOND 6398 ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:** 

D

В

1) MATERIAL: MANUFACTURED FROM D6002-115

FINISHED LENGTH = 104.98±0.020

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 15.5 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

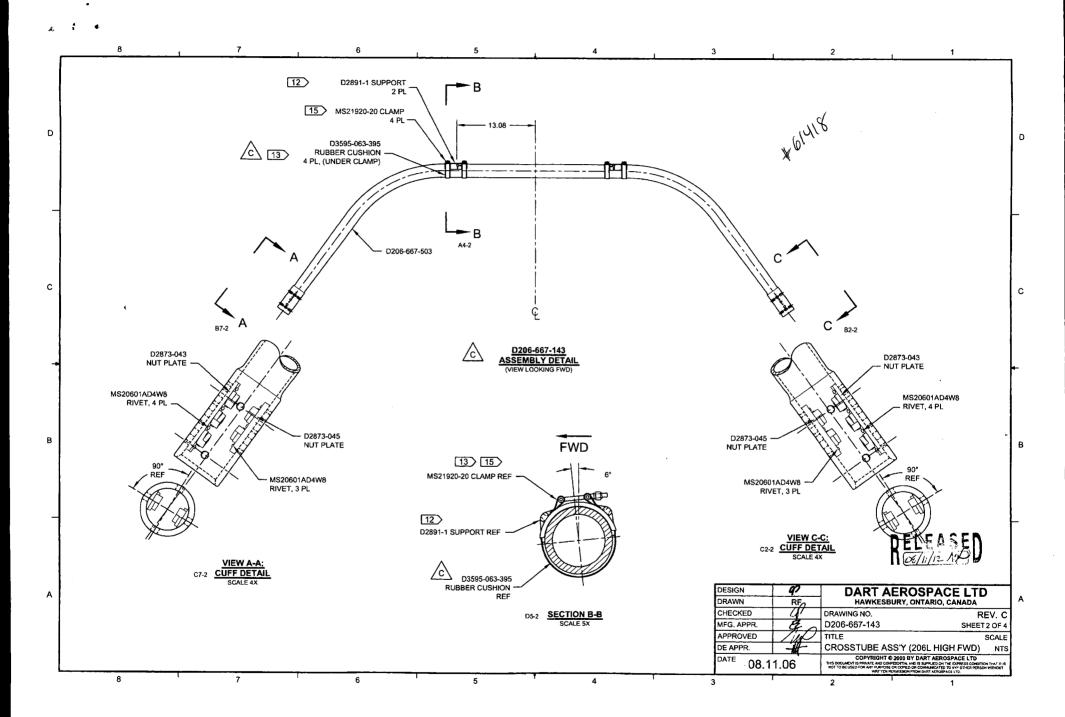


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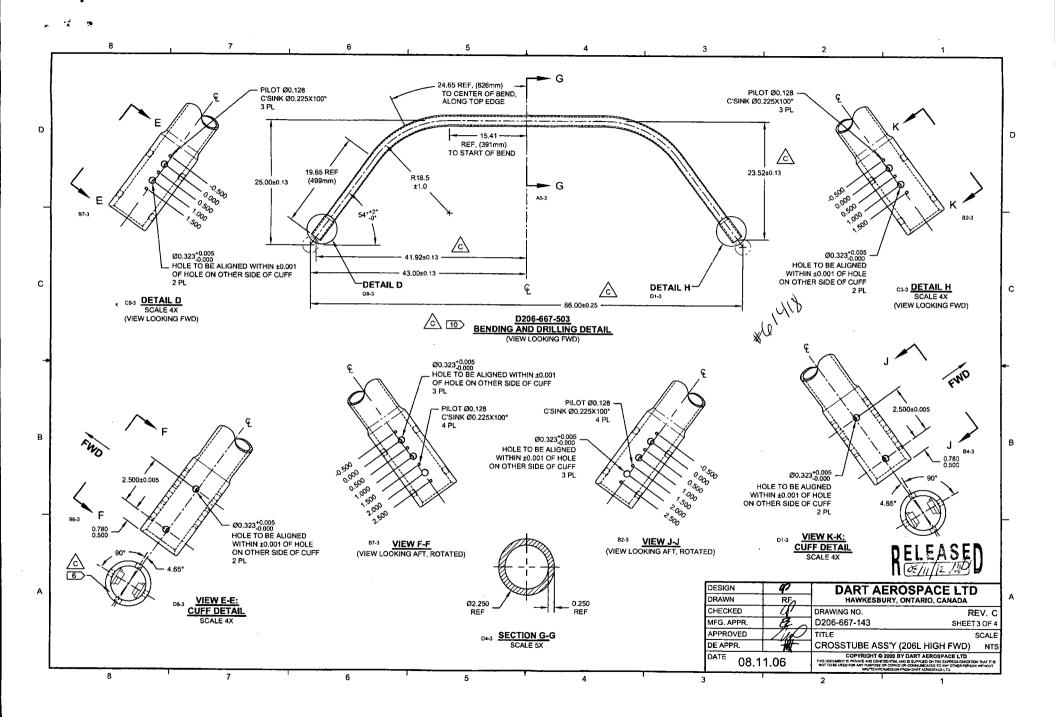
B ADD HOLES AND NUT PLATES FOR COMPATABILITY PH 05.07.26  A NEW ISSUE CP 00.11.17  REV. DESCRIPTION BY DATE  DESIGN P DART AEROSPACE LTD  DRAWN RF HAWKESBURY, ONTARIO, CANADA  CHECKED DRAWING NO. REV. C  APPROVED DESCRIPTION DY APPROVED TITLE SCALE  DE APPR CROSSTUBE ASSY (206L HIGH FWD) NTS  DATE 08.11.06	С	REORGA TO CUR D3595-0 REMOVI RELOCA	ANIZED VIEWS RENT STANDA 63-395 WAS D ED REF. & ADI ATED FLAG #6	TES/PART LIST (ZN D7-1); s AND REFORMATTED DRAWING RADS. 2856-400-694 (ZN D6-2 & A5-2); D TOLERANCE (ZN D3-3, C4-3, C5-3); (ZN A8-3) PER NCR 210; MOVED PDATED TOLERANCE TO SHEET 4.	RF	08.11.06		
REV. DESCRIPTION BY DATE  DESIGN P DART AEROSPACE LTD  DRAWN RF HAWKESBURY, ONTARIO, CANADA  CHECKED DRAWING NO. REV. CO  MFG. APPR. D206-667-143 SHEET1 OF 4  APPROVED TITLE SCALE  CROSSTUBE ASSY (206L HIGH FWD) NTS  COPYRIGHT 6 2000 BY DART AEROSPACE LTD  THE MOCCAMPINE TO 2000 BY DART AEROSPACE	В				₽H	05.07.26		
DESIGN PART AEROSPACE LTD  DRAWN RF CHECKED DRAWING NO. REV. O  MFG. APPR. D206-667-143 SHEET1 OF 4  APPROVED TITLE SCALE  DE APPR. CROSSTUBE ASSY (206L HIGH FWD) NTS  DATE 08.11.06	Α	NEW IS	SUE	CP	00.11.17			
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DRAWING NO.   DRAWING NO.   D206-667-143   SHEET 1 OF 4	DESIGN		P	DART AEROSPACE LTD				
MFG, APPR. D206-667-143 SHEET 1 0 F4  APPROVED TITLE SCALE DE APPR CROSSTUBE ASSY (206L HIGH FWD) NTS  DATE 08.11.06 TRANSPORTED ASSOCIATED BY DATE ARROPACE LTD  TO THE MODERNIA OF SOUTH OF SO	DRAWN		RF <sub>2</sub>	HAWKESBURY, ONTAR	IO, CAN	ADA		
APPROVED DE APPR.  DATE  08.11.06  TITLE  CROSSTUBE ASSY (206L HIGH FWD)  NTS  COPYRIGHT 6 2000 BY DART ARROSPACE LTD  TRANSCORDED STANDARD AND ARROSPACE LTD	CHECKE	D	a	DRAWING NO. REV				
DE APPR. CROSSTUBE ASSY (206L HIGH FWD) NTS  COPYRIGHT © 2000 BY DART ARROSPACE LTD  THE DOCARD'S SHOWLE NO COPYRIGHTON WITH B EMPHES DO HIGH SHOW IN COPYRIGHT IN IN IT IS  NOT THE OWN ARROSPACE TO	MFG. AP	PR.	E n	D206-667-143 SHEET 1 O				
DATE 08.11.06 COPYRIGHT © 2000 BY DART AEROSPACE LTD  THE SOCIAMENT IS PRIVATE AND COMPRISED HIS ARED ALE FOR THE SOCIAMENT CONTROL FROM THE PRIVATE BY THE SOCIAMENT CONTROL FROM THE PRIVATE BY THE B	APPROV	ED	/iss	TITLE SCALE				
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	R	esolution:	Disposition: QA: N/C Closed: Date:						
NCR:		\	WORK ORDE	R NON-CONFORM	ANCE (NCF	R)			
DATE	0750	Description of NC Corrective Action			ion B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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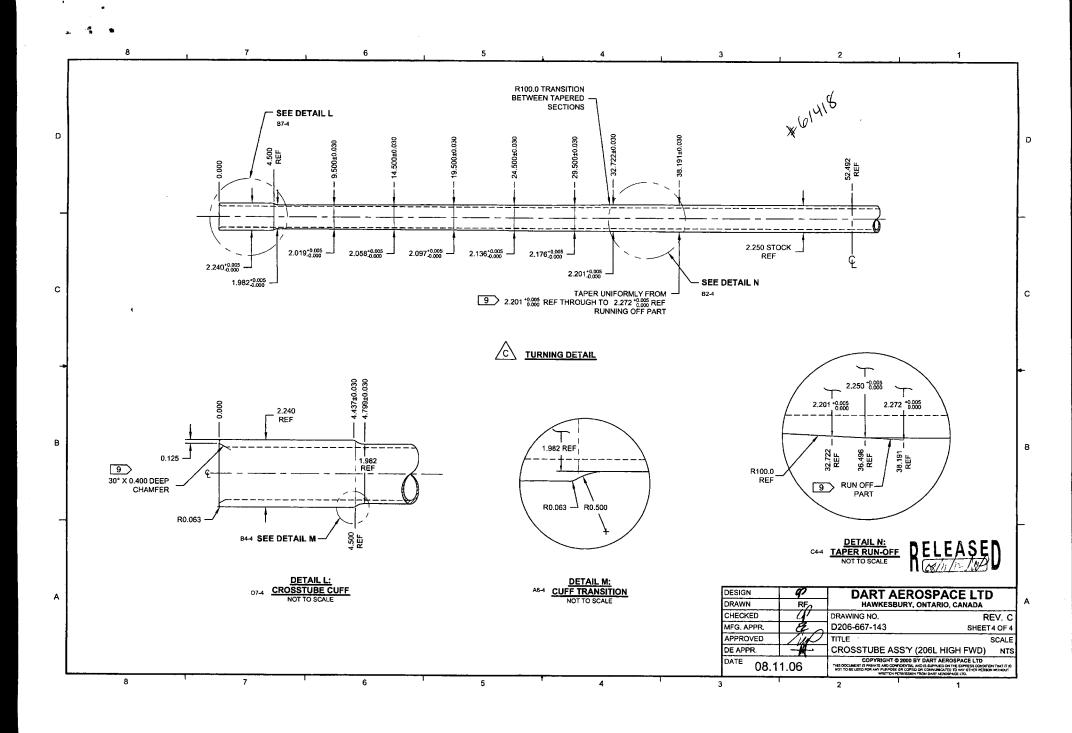


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DATE	STEP Description of NC			ion B	Verific	cation	Approval	Approval	
	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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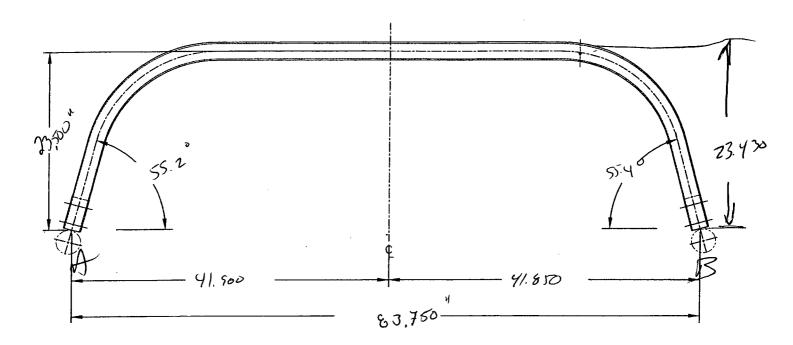
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DART AEROSPACE LTD	Work Order:	61418
Description: Crosstube High Fwd (206L)	Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.10



		Comments
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	QC15 Inspection Date	8
	Date	าไซโป

Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM	
В	09.06.26	Dimensions updated per Dwg Rev C	KJ	
С	09.10.22	Minimum height dimension revised	KJ	

W/O:			V	VORK ORDER CHANG	ES			· · · · · · · · · · · · · · · · · · ·	
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CLIENT	PART HEROSTACE	DATE	567-21,20,10 TIME	AM DE PM D
ATTENTION	LINDA / CHANTEL	ACUREN JOB NO.	188 - 10 - 088	37.
	270 ARRIDEEN ST.	PO/WO No.	12615 -	0
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PROJECT	FIF	(10) ON CE	SS TUBES E	
ITEM(S) EXAMINED	(7) MACHINED	PAZTS		
			_	
JOB DESCRIPTION	PROCEDURE NO. LTOOU IRE	//DATE TECH	HNIQUE NO. LT-(124 2 REV./DA	TE
	TROCEBOKE NO. 21000 XI		The second secon	
PART NO.		MATERIAL ATTION	LESS STIFF THICKNESS	
SCOPE WET	FLORESCENT LIQUI	D TENETRAN	77 + ALUDIA	=D Alaunial
INSPE	CTION CARRIED OF	7 ON 100%	S EXTERNAL -	SWLFACE_
TEST DETAILS				<del></del>
METHOD	FLUORESCENT UVISIBLE	☑ WATER WASH	☐ SOLVENT REMOVABLE	☐ Post Emulsified
FAMILY BRAND	MAKNAFLUX	BLACK LIGHT S/N //o	454 □ OUTPUT > 1000 µ W/cm²	☐ AMBIENT < 2 fc
PENETRANT 2L	67 MINIMUM DWELL TIME 45 16	MIN. LIGHTING EQUIP. DFL	ASHLIGHT 🛘 TROUBLELIGHT 🚨 OUT	PUT>100 fc@ SURFACE
PENETRANT REMOVER	H20 MINIMUM DRY TIME >10	Min. OTHER	-AG,NO	
DEVELOPER %	<del></del>	Min. Light Meter S/N	1098866 CALDU	EDATE OCT /1
	Í NON AQUEOUS 🔲 AQUEOUS 🔲 DF	RY		7070
TEST SURFACE		MACHINED	SHOT BLASTED	CLEAN BARE METAL
SURFACE CONDITION SURFACE TEMPERATURE	☐ AS GROUND ☐ AS WELDED ☐ < - 4°C/20°F TO			> 52°C/125°F
	METRIC   IMPERIAL)	10 0/00 1	10 0/00 1 10 01 0/120 1	
VESOF19- /	WEIRIC WINDERIAL)			· · · · · · · · · · · · · · · · · · ·
	-12 No 1 2100 /	,	$(A_{ij},A_{ij}) = (A_{ij},A_{ij}) = (A_{ij},A_{ij})$	
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2				•
1 (10557)	BE JULO 62278/V			•
1 60,557	BE-DID O 6209911			
1 00000	E-50.0.019 101/			
1 00000 TUE	202000			
1 CLOSS TUL	3E+W.O. 614 13/			•
1 10052 Tue	25000 619 3 17V			
1 C205574	BE700, 617 3811		NS ON CLOSSTUB	68
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Scope of Services The agreement of Acuren Group Inc. t	o perform services extends only to those services provided for in w	riting. Under no circumstances shall such serv	vices extend beyond the performance of the requested	services. It is expressly understood
that all descriptions, comments and ex representations or warranties. Acurer	pressions of opinion reflect the opinions or observations of Acuren (Group Inc. is not assuming any responsibilities of the owner/oper	Group Inc. based on information and assump ator and the owner/operator retains complete :	tions supplied by the owner/operator and are not inte responsibility for the engineering, manufacture, repai	nded nor can they be construed as ir and use decisions as a result of the
data or other information provided by Standard of Care	Acuren Group Inc. In no event shall Acuren Group Inc.'s liability	in respect of the services referred to herein exc	reed the amount paid for such services.	
In performing the services provided, A	curen Group Inc. uses the degree, care and skill ordinarily exercise	ed under similar circunstances by others perfo	orming such services in the same or similar locality.	No other warranty, expressed or
implied, is made or intended by Acure	n Group Inc.		The company type is a section of the	
SIGNATURES				
CLIENT REPRESENTATIVE	eric blowing		DTR# EG	339/
TECHNICIAN (SIGNATURE):	PRINTY	SIGNATURE	REPORT	
LOTATOWAY (OIGHATORE).	Miles Fill of		REVIEWED BY:	
NAME (PRINT):	MIKE / Jethes/ou	0,10	NAME	INITIALS
	CGSB LEVEL SNT LEVEL	2 <sup>ND</sup> TECHNICIAN CGSB LEVEL SNT LEVEL		
		CGSB REG. No		
			<del></del>	